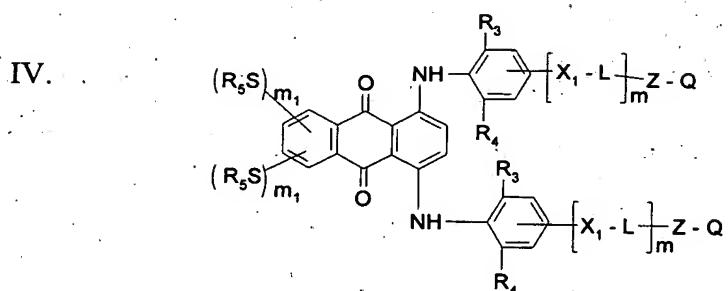
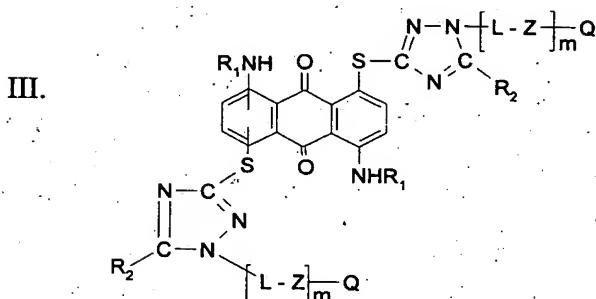
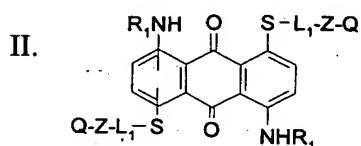
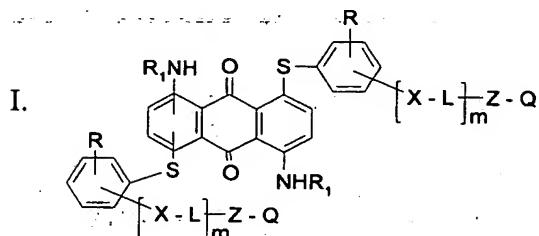
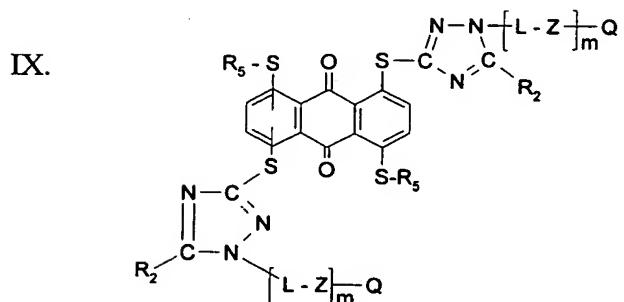
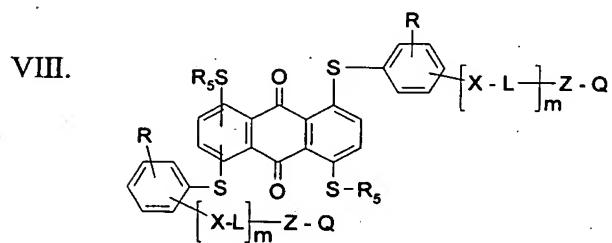
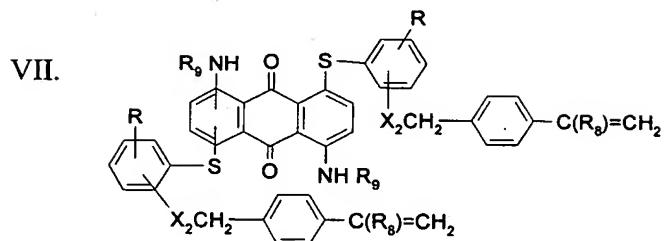
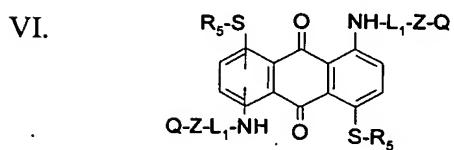
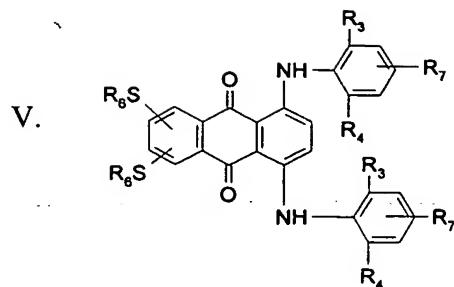


CLAIMS

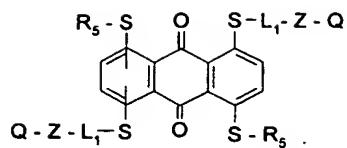
We claim:

1. Anthraquinone dye compounds having the formulae:

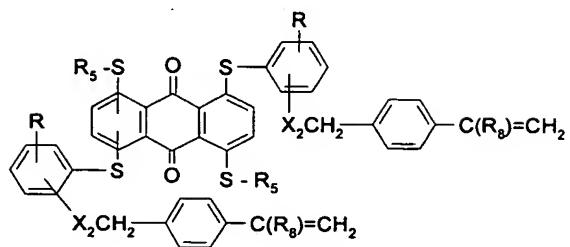




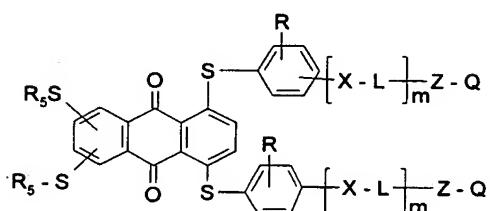
X.



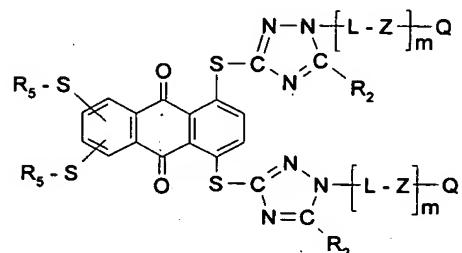
XI.



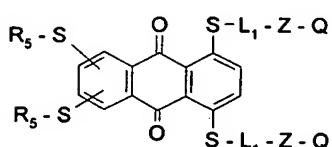
XII.



XIII.

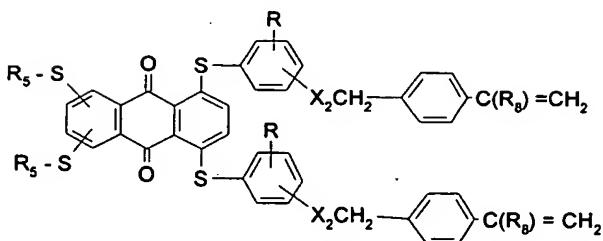


XIV.

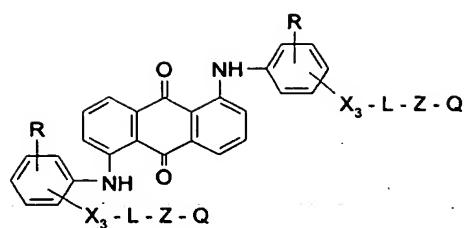


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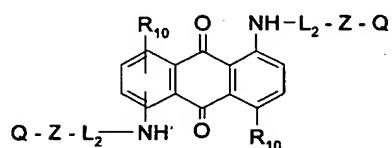
XV.



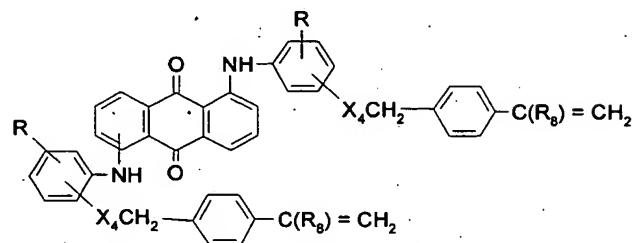
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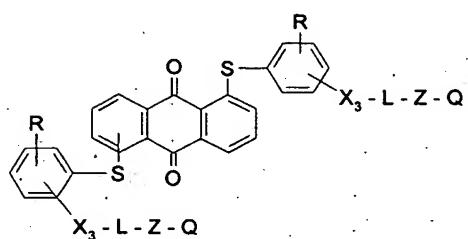
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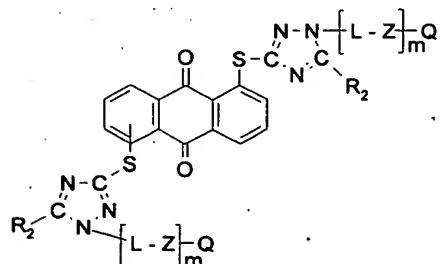
XVIII.



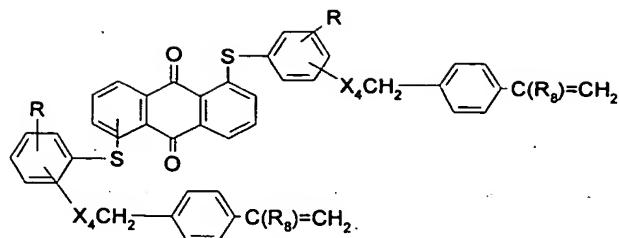
XIX.



XX.



XXI.



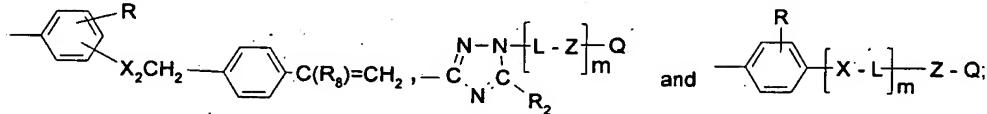
wherein:

R is selected from hydrogen or 1-3 groups selected from C₁ - C₆-alkyl, C₁ - C₆-alkoxy and halogen;

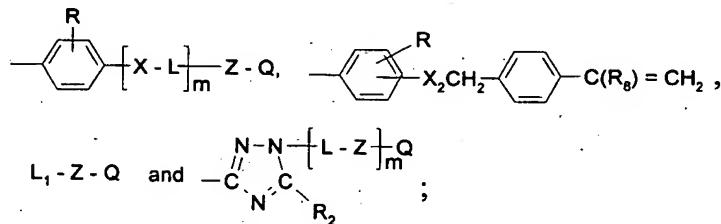
5 R₁ is selected from C₁ - C₆-alkyl, substituted C₁ - C₆-alkyl, C₃ - C₈-alkenyl, C₃ - C₈-cycloalkyl, aryl and -L₁-Z-Q; R₂ = selected from hydrogen, C₁ - C₆-alkyl, substituted C₁ - C₆-alkyl, C₃ - C₈-cycloalkyl and aryl;

R₃ and R₄ are independently selected from C₁ - C₆-alkyl and bromine;

10 R₅ is selected from C₁ - C₆-alkyl, substituted C₁ - C₆ alkyl, C₃ - C₈-cycloalkyl, aryl, heteroaryl, -L₁-Z-Q,



R₆ is selected from



15 R₇ is selected from hydrogen, substituted or unsubstituted C₁ - C₆-alkyl, C₁ - C₆-alkoxy, halogen, hydroxy, substituted or unsubstituted C₁ - C₆-alkylthio, sulfamoyl and substituted sulfamoyl;

R₈ is selected from hydrogen and C₁ - C₆-alkyl;

R₉ is selected from the groups represented by R₁ and -L - Z - Q;

R₁₀ is selected from hydrogen and halogen;

X is a covalent bond or a divalent linking group selected from -O-, -S-, -SO₂-, -CO₂-, -CON(Y)- and -SO₂N(Y)-, wherein Y is selected from hydrogen, C₁-C₆-alkyl, substituted C₁-C₆-alkyl, C₃-C₈-cycloalkyl, C₃-C₈-alkenyl, aryl and 5 -L-Z- Q;

X₁ is selected from -O-, -S-, -SO₂- and -SO₂N(Y)-;

X₂ is selected from -CO₂- and -SO₂N(Y₁), wherein Y₁ is a group selected from hydrogen, C₁-C₆-alkyl, substituted C₁-C₆-alkyl, C₃-C₈-alkenyl, C₃-C₈-cycloalkyl, aryl, heteroaryl and -CH₂-p-C₆H₄-C(R₈)=CH₂;

10 X₃ is selected from -CO₂-, -SO₂N(Y)-;

X₄ is selected from -CO₂-, -O- and -SO₂N(Y₁)-;

L is a divalent linking group selected from C₁-C₈-alkylene, C₁-C₆-alkylene-arylene, arylene, C₁-C₆-alkylene-arylene -C₁-C₆-alkylene, C₃-C₈-cycloalkylene, C₁-C₆-alkylene -C₃-C₈-cycloalkylene -C₁-C₆-alkylene, C₁-C₆-alkylene - Z₁-arylene 15 -Z₁-C₁-C₆-alkylene and C₂-C₆-alkylene-[Z₁-C₂-C₆-alkylene-]_n- wherein Z₁ is selected from -O-, -S- and -SO₂- and n is 1-3;

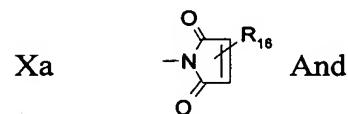
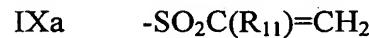
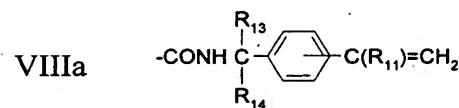
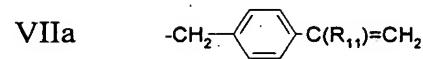
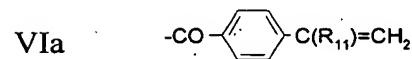
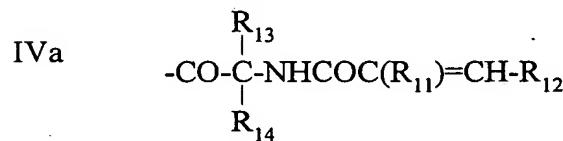
L₁ is a divalent linking group selected from C₂ - C₆-alkylene, C₁-C₆-alkylene-C₃-C₈-cycloalkylene-C₁-C₆-alkylene, C₁-C₆-alkylene-arylene, C₃-C₈-cycloalkylene, and C₂-C₆-alkylene-[Z₁-C₂-C₆-alkylene-]_n-;

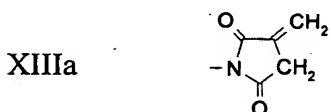
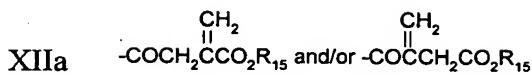
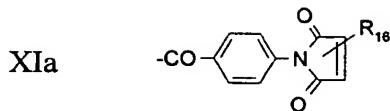
20 L₂ is selected from C₂-C₆-alkylene, C₁-C₆-alkylene- arylene-C₁-C₆ alkylene and C₁-C₆-alkylene-C₃-C₈-cycloalkylene-C₁-C₆-alkylene;

Z is a divalent group selected from -O-, -S-, -NH-, -N(C₁-C₆-alkyl)-, -N(C₃-C₈ alkenyl)-, -N(C₃-C₈ cycloalkyl)-, -N(aryl)-, -N(SO₂C₁-C₆-alkyl) and -N(SO₂ aryl)-, provided that when Q is a photopolymerizable optionally substituted maleimide radical, Z represents a covalent bond; Q is an ethylenically-unsaturated, 25 photosensitive polymerizable group; and

m and m₁ each is 0 or 1.

2. Anthraquinone compounds according to Claim 1 wherein the ethylenically-unsaturated, photosensitive copolymerizable groups represented by Q are selected from the following organic radicals:





wherein:

R₁₁ is selected from hydrogen and C₁-C₆-alkyl;

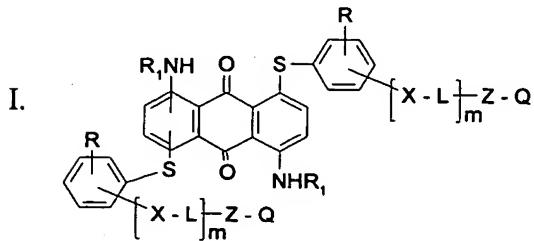
5 R₁₂ is selected from hydrogen; C₁-C₆-alkyl; phenyl and phenyl substituted with one or more groups selected from C₁-C₆-alkyl, C₁-C₆-alkoxy, -N(C₁-C₆-alkyl), nitro, cyano, C₁-C₆-alkoxycarbonyl, C₁-C₆-alkanoyloxy and halogen; 1- and 2-naphthyl which may be substituted with C₁-C₆-alkyl or C₁-C₆-alkoxy; 2- and 3-thienyl which may be substituted with C₁-C₆-alkyl or halogen; 2- or 3-furyl which may be substituted with C₁-C₆-alkyl;

10 R₁₃ and R₁₄ are selected from hydrogen, C₁-C₆-alkyl, substituted C₁-C₆-alkyl, aryl or may be combined to represent a -[-CH₂-]₃₋₅₋ radical;

R₁₅ is selected from hydrogen, C₁-C₆-alkyl, substituted C₁-C₆-alkyl, C₃-C₈-alkenyl, C₃-C₈-cycloalkyl and aryl;

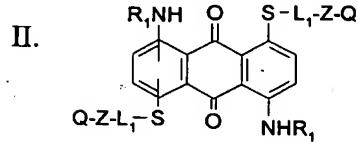
R₁₆ is selected from hydrogen, C₁ - C₆-alkyl and aryl.

15 3. Anthraquinone compounds according to Claim 2 having the formula:



wherein Z is -O-.

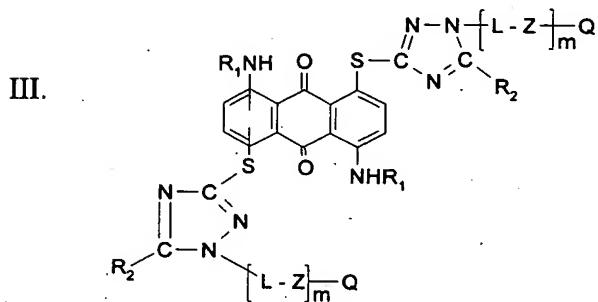
4. Anthraquinone compounds according to Claim 2 having the formula:



wherein Z is $-O-$.

5

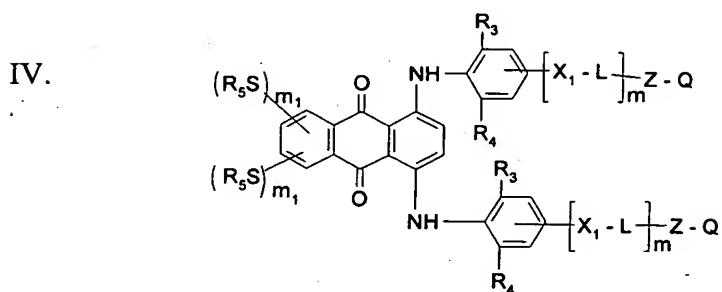
5. Anthraquinone compounds according to Claim 2 having the formula:



wherein Z is $-O-$.

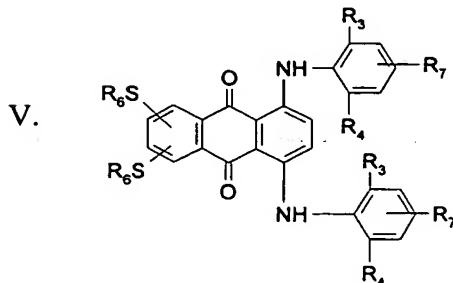
10

6. Anthraquinone compounds according to Claim 2 having the formula:



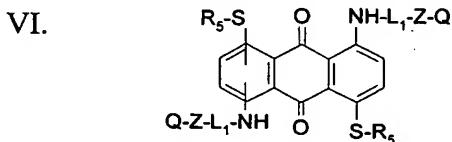
wherein Z is $-O-$.

7. Anthraquinone compounds according to Claim 2 having the formula:



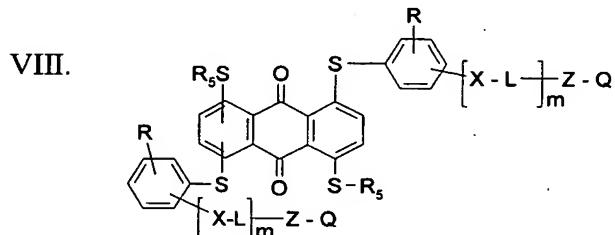
wherein Z is -O-.

5 8. Anthraquinone compounds according to Claim 2 having the formula:



wherein Z is -O-.

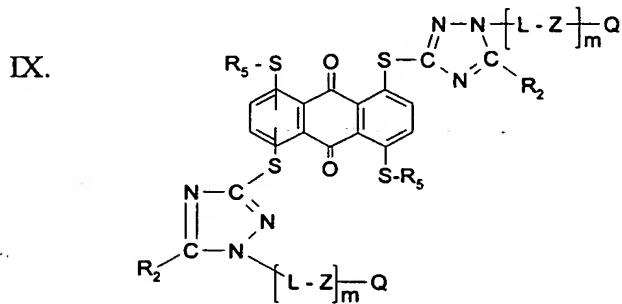
9. Anthraquinone compounds according to Claim 2 having the formula:



10

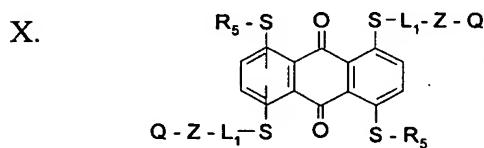
wherein Z is -O-.

10. Anthraquinone compounds according to Claim 2 having the formula:



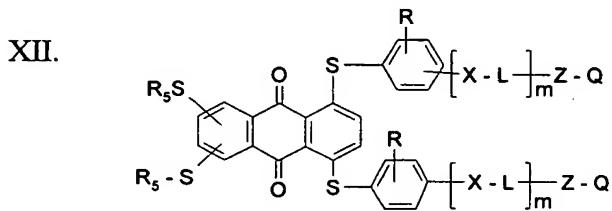
wherein Z is $-O-$.

5 11. Anthraquinone compounds according to Claim 2 having the formula:



wherein Z is $-O-$.

12. Anthraquinone compounds according to Claim 2 having the formula:

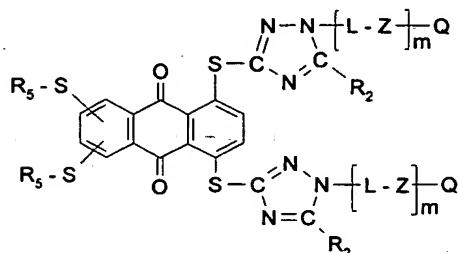


10

wherein Z is $-O-$.

13. Anthraquinone compounds according to Claim 2 having the formula:

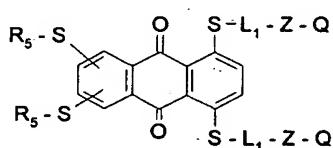
XIII.



wherein Z is -O-.

5 14. Anthraquinone compounds according to Claim 2 having the formula:

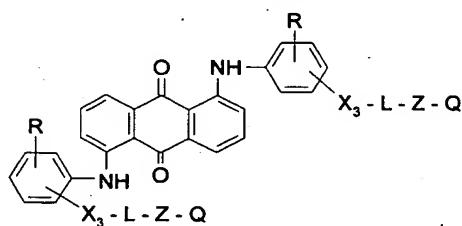
XIV.



wherein Z is -O-.

15. Anthraquinone compounds according to Claim 2 having the formula:

XVI.

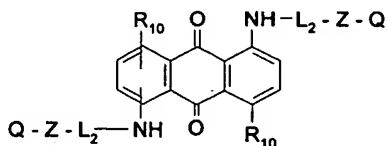


10

wherein Z is -O-.

16. Anthraquinone compounds according to Claim 2 having the formula:

XVII.

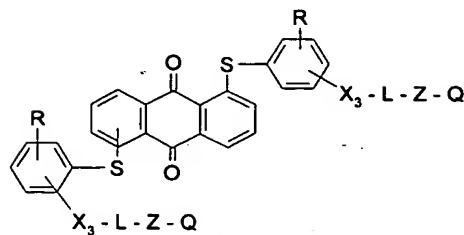


15

wherein Z is -O-.

17. Anthraquinone compounds according to Claim 2 having the formula:

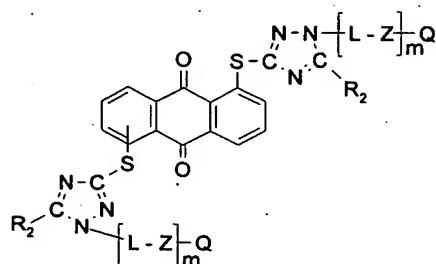
XIX.



wherein Z is -O-.

5 18. Anthraquinone compounds according to Claim 2 having the formula:

XX.



wherein Z is -O-.

19. Anthraquinone compounds according to Claim 2 wherein Q is organic

10 radical Ia.

20. Anthraquinone compounds according to Claim 2 wherein Q is organic radical Ia wherein R₁₁ is hydrogen or methyl and R₁₂ is hydrogen.

15 21. Anthraquinone compounds according to Claim 2 wherein Q is organic radical VIIa.

22. Anthraquinone compounds according to Claim 2 wherein Q is organic radical VIIa wherein R₁₁ is hydrogen.

23. Anthraquinone compounds according to Claim 2 wherein Q is organic radical VIIia.

5 24. Anthraquinone compounds according to Claim 2 wherein Q is organic radical VIIia wherein R₁₁ is hydrogen or methyl and R₁₃ and R₁₄ are methyl.

25. Anthraquinone compounds according to Claim 3 wherein X is -CO₂-, L is -CH₂CH₂-, and m is 1.

10 26. Anthraquinone compounds according to Claim 5 wherein L is -CH₂CH₂-, m is 1, and R₂ is hydrogen.

27. Anthraquinone compounds according to Claim 8 wherein L₁ is -CH₂C(CH₃)₂CH₂- and R₅ is aryl.

15 28. Anthraquinone compounds according to Claim 9 wherein X is -CO₂-, L is -CH₂CH₂-, and m is 1.

29. Anthraquinone compounds according to Claim 10 wherein L is -CH₂CH₂-, R₂ is hydrogen and m is 1.

20 30. Anthraquinone compounds according to Claim 12 wherein X is -CO₂-, L is -CH₂CH₂-, and m is 1.

25 31. Anthraquinone compounds according to Claim 13 wherein L is -CH₂CH₂-, R₂ is hydrogen and m is 1.

32. Anthraquinone compounds according to Claim 15 wherein X₃ is -CO₂-, L is -CH₂CH₂-, and R is hydrogen or bromine.

33. Anthraquinone compounds according to Claim 15 wherein X_3 is $-CO_2-$, L is propylene, 1,4-cyclohexylenedimethylene or 2,2-dimethyltrimethylene, R is hydrogen, Z is $-O-$, and Q is an organic radical having the structure $-COC(R_{11})=CH_2$ wherein R_{11} is hydrogen, methyl or ethyl.

5

34. Anthraquinone compounds according to Claim 15 wherein X_3 is $-CO_2-$, L is propylene, 1,4-cyclohexylenedimethylene or 2,2-dimethyltrimethylene, R is hydrogen, Z is $-O-$, and Q is an organic radical having structure VIIIa wherein R_{11} , R_{13} and R_{14} each is methyl.

10

35. Anthraquinone compounds according to Claim 16 wherein L_2 is $-CH_2C(CH_3)_2CH_2-$, and R_{10} is hydrogen.

15

36. Anthraquinone compounds according to Claim 17 wherein X_3 is $-CO_2-$, L is $-CH_2CH_2-$, and R is hydrogen.

20

37. Anthraquinone compounds according to Claim 17 wherein X_3 is $-CO_2-$, L is propylene, 1,4-cyclohexylenedimethylene or 2,2-dimethyltrimethylene, R is hydrogen, Z is $-O-$, and Q is an organic radical having the structure $-COC(R_{11})=CH_2$ wherein R_{11} is hydrogen, methyl or ethyl.

25

38. Anthraquinone compounds according to Claim 17 wherein X_3 is $-CO_2-$, L is propylene, 1,4-cyclohexylenedimethylene or 2,2-dimethyltrimethylene, R is hydrogen, Z is $-O-$, and Q is an organic radical having structure VIIIa wherein R_{11} , R_{13} and R_{14} each is methyl.

39. Anthraquinone compounds according to Claim 18 wherein L is $-CH_2CH_2-$, R_2 is hydrogen, and m is 1.

40. Anthraquinone compounds according to Claim 6 wherein X is $-\text{SO}_2\text{N}(\text{Y})-$, L is C₂-C₆ alkylene, R₃ and R₄ are methyl or ethyl, Y is hydrogen, m is 1 and m₁ is 0.

5 41. Anthraquinone compounds according to Claim 6 wherein X is $-\text{SO}_2\text{N}(\text{Y})-$, L is C₂-C₆ alkylene, R₃ and R₄ are methyl or ethyl, Y is hydrogen, m is 1 and m₁ is 1.

10 42. Anthraquinone compounds according to Claim 1 having formula VII wherein X₂ is -CO₂- and R and R₈ are hydrogen.

43. Anthraquinone compounds according to Claim 1 having formula XI wherein X₂ is -CO₂- and R₁ and R₈ are hydrogen.

15 44. Anthraquinone compounds according to Claim 1 having formula XVII wherein X₄ is -CO₂- and R and R₈ are hydrogen.

45. Anthraquinone compounds according to Claim 1 having formula XXI wherein X₄ is -CO₂- and R and R₈ are hydrogen.

20 46. Anthraquinone compounds according to Claim 1 having formula IV wherein X₁ is -O-, Z is -O-, L is -CH₂CH₂-, R₃ and R₄ are methyl or ethyl, m is 1 and m₁ is 0.

25 47. A coating composition comprising (i) one or more polymerizable vinyl compounds, (ii) one or more of the dye compounds of Claim 1, and (iii) a photoinitiator.

30 48. A coating composition according to Claim 47 comprising (i) one or more polymerizable vinyl compounds, (ii) one or more of the dye compounds of Claim 2

present in a concentration of about 0.05 to 15 weight percent based on the weight of component (i), and (iii) a photoinitiator present in a concentration of about 1 to 15 weight percent based on the weight of the polymerizable vinyl compound(s) present in the coating composition.

5

49. A coating composition according to Claim 48 wherein the polymerizable vinyl compounds comprise a solution of a polymeric, polymerizable vinyl compound selected from acrylated and methacrylated polyesters, acrylated and methacrylated polyethers, acrylated and methacrylated epoxy polymers, acrylated or methacrylated urethanes, and mixtures thereof, in a diluent selected from monomeric acrylate and methacrylate esters.

10

50. A polymeric coating composition comprising a polymer of one or more acrylic acid esters, one or more methacrylic acid esters and/or other copolymerizable vinyl compounds, having copolymerized therein one or more of the dye compounds defined in Claim 1.

15

51. A polymeric composition according to Claim 50 comprising a coating of an acrylic polymer of one or more acrylic acid esters, one or more methacrylic acid esters or a mixture thereof having copolymerized therein one or more of the dye compounds defined in Claim 2.

20

52. A polymeric composition according to Claim 50 comprising a coating of an unsaturated polyester containing one or more maleate/fumarate residues; one or more monomers which contain one or more vinyl ether groups, one or more vinyl ester groups, or a combination thereof, and, optionally, one or more acrylic or methacrylic acid esters; or a mixture thereof having copolymerized therein one or more of the dye compounds defined in Claim 2..

25

53. A polymeric coating according to Claim 51 containing from about 0.05 to 15.0 weight percent of the residue of one or more of the dye compounds of Claim 2 based on the weight of the coating.